

# Work Order ID 52262

September 22, 2009 7:42:01 AM



Item ID: D412-694-04

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Door Assembly

Start Date: 9/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 09/09/27 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D412-694

Rev C1

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Issue red decal labels for D412-694-04. CHG005

Handwritten: BG 11-9-27

110

0.00



Small Fab

COMPOSITE ASSEMBLY

Memo

0.00

Small Fab

D412-694-04 Drill Process 11- Drill pilot holes Ø(#30) using Dwg Tool D3140-303A for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T11/T12 as per Dwg D412-694 page 3. Note: Ensure slot is aligned

Handwritten: RT 09.11.30

Handwritten: PTO

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Handwritten: 2) Sals...

W/O: 52262

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-694-04 PAR #: N/A Fault Category: Sm. Feb NCR: Yes No DQA: A Date: 11-11-03  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: C Date: 11/11/04

NCR: 11-950

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		3159-041 Drilled wrong		x2 scrap + replace in <u>50391</u> x2	ET 09/12/04			
10-01-06 11/11/04	110	3143-1 threads screwed up Re: 1 of 1.		x2 scrap + replace in 10536-1	ET 09/12/04	10-01-06		10-01-06

NOTE: Date &amp; initial all entries

# Work Order ID 52262

September 22, 2009 7:42:01 AM



Page 2

Item ID: D412-694-04

Revision ID: C1

Item Name: Door Assembly

Start Date: 9/22/09 Start Qty: 1.00

Required Date: 11/13/09 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

COMPOSITE ASSEMBLY

Memo

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM). 12- Sand flush excess Hysol around the insert on both doors.

0.00

0.00

Hysol 934

m ~~113022~~

m 113118 RT 09-11-30

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Inspect that inserts are flush with the surface.

0.00

0.00

2) Seal w/20

150



Small Fab

Small Fab

COMPOSITE ASSEMBLY

Memo

1. Apply primer filler and reducer around the inserts on both doors. 11A/R

11045 Primer Filler

Batch: 112384 11A/R

12375S Reducer

Batch: 112960

0.00

0.00

RT 09-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52262

September 22, 2009 7:42:01 AM

Page 3

Item ID: D412-694-04

Revision ID: C1

Item Name: Door Assembly

Start Date: 9/22/09 Start Qty: 1.00

Required Date: 11/13/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

QC14

Memo

0.00

0.00

1.00

09

12

03

03

PTO

170



Small Fab

Small Fab

COMPOSITE ASSEMBLY

Memo

D412-694-04 Assembly Process: 11- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF). 12- Install D3111-041 Plate Assembly. If needed, insta

0.00

0.00

PT

10-01-06

PTO

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Install door on mock up helicopter to insure proper fit and function.

0.00

0.00

PT

10-01-06

# Dart Aerospace Ltd

W/O: 52262		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-01-07	160	Should be a QC 14. Perm. Change	<i>[Signature]</i>	11.10.31	N/A	<i>[Signature]</i>	<i>[Signature]</i>	

*NCR x 2*

① Design

Part No: D412-694-04 PAR #: N/A Fault Category: Sm Tab NCR: Yes No DQA: [Signature] Date: 11.11.03

Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 11/11/04

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-01-06	170	3111-041 plate assy to close to door interferes w/movement of handle	<i>[Signature]</i>	* Install AN9605D10LL washers to allow for more clearance AN9605D10LL M 19600 x4	<i>[Signature]</i> 10-01-06	<i>[Signature]</i>	<i>[Signature]</i>	
10-01-06	170	screw had crazy glue on threads from sealing up hole. ended up cross threading screws + nuts	<i>[Signature]</i>	scrap + replace screws x2/M521042 L06 M112243 and nuts x2/M521042 L06 M112243	<i>[Signature]</i> 10-01-06	<i>[Signature]</i>	<i>[Signature]</i>	

$38d \times 2 = .04$   
 $.04 \times 2 = .08$   
 $.08 \times 2 = .16$

NOTE: Date & initial all entries

# Work Order ID 52262

September 22, 2009 7:42:01 AM



Page 4

Item ID: D412-694-04

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Setup Start



Revision ID: C1

Item Name: Door Assembly

Stop



Start Date: 9/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

0.00



Small Fab

Small Fab

Memo

0.00

(Put red label inside before putting the cover D3119-042/or Vip trim)

Small Fab

81 11-09-30

200

0.00



Identify as per dwg & Stock Location: \_\_\_\_\_

Packaging

Memo

0.00

Packaging

210

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

PPP 52260

11/10/58

11/10/31 JF  
mrf  
11-10-27

W/O: 52262		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-09-30	190	Acceptable to use Qty (2) MS 51859-7 washers instead of 3 ref shown in BB-BB. acceptable used as spacers	JS	11-09-30	1	11.09.27 Qty 042	11-09-28

Part No: D412-694-04 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

September 22, 2009 7:42:00 AM

Page 1

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09



Required Date: 11/13/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS43DD3-40  Spacer		Purchased	No			110	Each	15.0000	2.0000 	9/16/24	9/16/24	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	15	
110153	10	
112314	5	

80-005-2-8  Insert		Purchased	No			170	Each	147.0000	21.0000 			
--	--	-----------	----	--	--	-----	------	----------	--	--	--	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	147	
112439	20	
19443	127	

A4S4-632-80  Insert		Purchased	No			170	Each	255.0000	10.0000 			
---	--	-----------	----	--	--	-----	------	----------	--	--	--	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	255	
112495	200	
17841	55	

11/13/09 9/16/24  
9/16/24 sp @

10x5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN525-T0R7



Screw

Purchased

No

170

Each

163.0000

4.0000



9/16/24 sf

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

163

106166

30

110844

15

112314

18

112411

100

4x sf

AN960JD10



Washer

Purchased

No

170

Each

2,117.000

8.0000



9/16/24 sf

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

2117

105442

95

109059

2

109840

23

110985

202

111279

5

111668

64

112314

1000

112369

726

8x sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 52262

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Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JDTOL  Washer		Purchased	No			170	Each	6,445.000	13.0000			

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6445	
101291	16	
104885	153	
105793	236	
109632	1040	
110985	5000	

AN960JDTOLL  Washer	Purchased	No				170	Each	4,077.000	29.0000			
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13x SP  
9/11/24 SP  
(12)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4077	
19085	376	
19600	3701	

29x SP

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD6L  Washer		Purchased	No			170	Each	1,405.000	4.0000		9/11/24	SP

Warehouse                      Loc Qty                      Loc Code  
Location


Main Warehouse

ST

1405

5519

1405

AN960JD8  
  
Washer

Purchased

No

170

Each

1,775.000 2.0000

4x SP

9/11/24

SP

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

1775

107091

9

108335

11

110382

48

110917

3

111578

404

112314

500

112385

800

2x SP

# Picklist Print

September 22, 2009 7:42:00 AM

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Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8L  Washer		Purchased	No			170	Each	503.0000	2.0000 		9/11/24 sl	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	503	

6956

Purchased	No		170	Each	270.0000	34.0000 
-----------	----	--	-----	------	----------	--

5x5

M112794 9/11/24 sl

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	270	
107296	270	
11821	0	

Purchased	No		170	Each	412.0000	12.0000 
-----------	----	--	-----	------	----------	--

9/11/24 sl

(12)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	412	
101237	112	
112540	300	
14230	0	

12x5



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Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3110-1RevC  Escutcheon		Manufactured	No			170	Each	2.0000	1.0000	25	09-02-10	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
31757	2	


B54198

D3110-3RevC  Handle		Manufactured	No			170	Each	5.0000	1.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

9/14/09 30

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
50041	5	

128

D3111-041RevB  Plate Assembly		Manufactured	No			170	Each	121.0000	1.0000			
---	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

9/14/24 50

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	121	
1053613	121	

128

# Picklist Print

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Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3112-1RevB 		Manufactured	No			170	Each	17.0000	2.0000			
Guide										9/14/09		SL

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
23698	0	
41644	7	

Main Warehouse		
ST66	10	
50304	10	

D3113-1RevB 		Manufactured	No			170	Each	17.0000	1.0000			
Spring										9/14/09		SL

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	17	
36725	17	

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Parent Item Name: Door Assembly



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Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3114-11RevB  Pivot		Manufactured	No			170	Each	17.0000	1.0000 		9/14/24 SD	

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

17

36726

17

D3116-11RevA

Manufactured

No

170

Each

778.0000

1.5000  


1x SD

9/11/24

SD

Seal

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

778

27241

778

D3116-5RevA

Manufactured

No

170

f

672.0100

5.6700  


1x SD

9/11/24

SD

Seal

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

672.01

23699

18

27208

654.01

1x SD

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Comments:

Start Date: 9/22/09

Required Date: 11/13/09


Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3119-042RevB		Manufactured	No			170	Each	1.0000	1.0000			
												
Cover Assembly												

9/11/24 SP


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
27725	1	

D3120-2RevB		Manufactured	No			170	Each	6.0000	1.0000			
												
Cover												

52691 SP

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
50344	6	

D3120-4RevB		Manufactured	No			170	Each	3.0000	1.0000			
												
Cover												

66220

1x SP

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
50337	3	

1x SP

# Picklist Print

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Comments:

Start Date: 9/22/09

Required Date: 11/13/09


Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3125-1RevC.  Lever		Manufactured	No			170	Each	54.0000	1.0000			


9/11/24 SF

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	54	
1053617	54	

D3125-1RevC.  Lever		Manufactured	No			170	Each	105.0000	1.0000			
--	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

9/11/24 SF

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	105	
1053617	105	

D3125-5RevC.  Lever		Manufactured	No			170	Each	119.0000	1.0000			
--	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

9/11/24 SF

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Premier		
Mezz	119	
1053617	119	

1x SF

# Picklist Print

September 22, 2009 7:42:00 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3125-7RevC  Lever		Manufactured	No			170	Each	98.0000	1.0000			

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	98	
1053617	98	


1x SP

D3129-1RevB  Lever		Manufactured	No			170	Each	255.0000	2.0000			
--	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	255	
1053617	255	

2x SP

D3130-1RevB  Clevis Base		Manufactured	No			170	Each	309.0000	2.0000			
--	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	309	
1053617	309	

2x SP

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
<del>D3131-1RevB</del> 		Manufactured	No			170	Each	98.0000	1.0000			
Stop												

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	98	
1053617	98	


1250

<del>D3134-1RevE</del> 		Manufactured	No			170	Each	6.0000	1.0000			
Rod												

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
27338	2	
50280	4	

1250

<del>D3134-4RevE</del> 		Manufactured	No			170	Each	8.0000	1.0000			
Rod												

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
18376	4	
50711	4	

1250

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3140-08RevE 		Manufactured	No			170	Each	0.0000	1.0000			
Door												
D3143-1RevB 		Manufactured	No			170	Each	21.0000	1.0000			
Clevis												

BS2262CY

9/11/24 SL

Warehouse      Loc Qty      Loc Code  
Location

Main Warehouse

ST

21

1053617

21

170

Each

175.0000

3.0000

1x SL

9/11/24

SL

Warehouse      Loc Qty      Loc Code  
Location

Main Warehouse

ST

175

1053617

175

170

Each

3.0000

1.0000

3x SL

9/11/24 SL

Warehouse      Loc Qty      Loc Code  
Location

Main Warehouse


ST

3


22022

3

1x SL

D3143-3RevB  


Clevis

D3144-117RevC  


Doubler



# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09


Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
 D3144-119RevC Doubler		Manufactured	No			170	Each	6.0000	1.0000	9/11/09 SL		

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	

 D3144-121RevC Doubler		Manufactured	No			170	Each	3.0000	1.0000			
--	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
22024	3	

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3145-2RevB  Bracket		Manufactured	No			170	Each	21.0000	1.0000 			

9/11/24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
22501	0	
31734	1	
Main Warehouse		
ST67	20	
50097	10	
50098	10	

1x50

D3146-2RevB  Bracket		Manufactured	No			170	Each	11.0000	1.0000 			
---	--	--------------	----	--	--	-----	------	---------	--	--	--	--

9/11/24 SP  
ke

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	11	
20738	0	
46928	1	
50100	10	

1x50

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09


Required Date: 11/13/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3147-1RevC  Pin		Manufactured	No			170	Each	21.0000	2.0000		9/11/24 SD	

<u>Warehouse</u>	<u>- Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	21	
41616	1	
41930	20	

D3149-1RevB  Striker Plate		Manufactured	No			170	Each	107.0000	2.0000		2xSD 9/11/24 SD	
--	--	--------------	----	--	--	-----	------	----------	--------	--	--------------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	107	
1053617	107	

D3150-1RevB  Guide		Manufactured	No			170	Each	21.0000	2.0000		2xSD 9/11/24 SD	
--	--	--------------	----	--	--	-----	------	---------	--------	--	--------------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	21	
1053617	21	

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3154-1RevB-1  Key		Manufactured	No			170	Each	43.0000	1.0000			

9/11/24 sl

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	43	
1053617	43	


1x50

D3157-1RevB-3  Spacer		Manufactured	No			170	Each	307.0000	2.0000			
---	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

9/11/24 sl

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	307	
1053617	307	

2x

D3159-041RevG-7  Bracket Assembly		Manufactured	No			170	Each	48.0000	3.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

9/11/24 sl

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	48	
18641	4	
50391	44	

1x50  
2x

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3159-044RevC7  Bracket Assembly		Manufactured	No			170	Each	2.0000	1.0000 	9/11/24 SD		

Warehouse Loc Qty Loc Code

Location


Main Warehouse

ST

2

1053617

2

FW10-032  
  
Washer

Purchased

No

170

Each

372.0000

16.0000  


24859 (10)  
9/11/24 SD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

372

101203

210

19249

162

Purchased

No

170

Each

120.0000

6.0000  


16x

9/11/24 SD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

120

101203

94

11822

26

16x SD

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M7885/3-4-4  Rivets		Purchased	No			170	Each	278.0000	2.0000		9/11/24	SP



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	278	
104625	100	
108077	178	

2x50

M7885/3-4-5  Rivet		Purchased	No			170	Each	80.0000	1.0000		9/11/24	SP
--	--	-----------	----	--	--	-----	------	---------	--------	---	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	80	
1408	80	

1x50

MS20392-1C11  Pin		Purchased	No			170	Each	75.0000	2.0000		9/11/24	SP
---	--	-----------	----	--	--	-----	------	---------	--------	---	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
18822	75	

250

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09



Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20392-2CTT  Pin		Purchased	No			170	Each	66.0000	2.0000 		9/11/09	SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	66	
14149	66	

MS20392-2CT5  Pin		Purchased	No			170	Each	58.0000	7.0000 		9/11/09	SP
---	--	-----------	----	--	--	-----	------	---------	---	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	58	
101334	15	
101340	43	

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L06  Nut		Purchased	No			170	Each	447.0000	2.0000 	9/11/24		scf

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	447	
110123	11	
110731	14	
111548	1	
112243	121	
112369	100	
112433	100	
112465	100	

2x scf

MS21042L3  Nut		Purchased	No			170	Each	3,663.000	7.0000 	9/11/24		scf
---	--	-----------	----	--	--	-----	------	-----------	--	---------	--	-----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3663	
110844	32	
111274	139	
111668	992	
112314	2000	
112385	500	

7x scf



# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09



Required Date: 11/13/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24665-151  Cotter Pin		Purchased	No			170	Each	949.0000	11.0000 		9/11/04	SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	949	
14526	70	
17566	879	

MS24694-C4  SCREW		Purchased	No			170	Each	268.0000	2.0000 		9/11/04	SP
---	--	-----------	----	--	--	-----	------	----------	---	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	268	
15924	268	

MS24694-S53  SCREW		Purchased	No			170	Each	11.0000	2.0000 		9/11/04	SP
--	--	-----------	----	--	--	-----	------	---------	---	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	11	
15798	11	

# Picklist Print

September 22, 2009 7:42:01 AM

Page 23

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24694-S56  SCREW		Purchased	No			170	Each	154.0000	4.0000			

9/11/24 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse


ST

154

104407

154

4xSP

MS24694-S60  Screw		Purchased	No			170	Each	229.0000	4.0000			
--	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

9/11/24

SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

229


104407

227

11766

2

4xSP

MS25281-R6  Clamp		Purchased	No			170	Each	92.0000	2.0000			
---	--	-----------	----	--	--	-----	------	---------	--------	--	--	--

9/11/24

SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

92

19098

92

2xSP

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09


Required Date: 11/13/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-06-1  Screw		Purchased	No			170	Each	1,020.000	12.0000		9/11/09	SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1020	
104289	1000	
106815	20	

MS27039-1-08-1  Screw		Purchased	No			170	Each	3,333.000	6.0000		9/11/09	SP
---	--	-----------	----	--	--	-----	------	-----------	--------	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3333	
110467	192	
110552	1141	
110835	2000	

MS35206-231-1  Screw		Purchased	No			170	Each	50.0000	2.0000		9/11/09	SP
--	--	-----------	----	--	--	-----	------	---------	--------	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	50	
11735	50	

# Picklist Print

September 22, 2009 7:42:01 AM

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS35650-305T  Nut		Purchased	No			170	Each	116.0000	4.0000		9/11/24	sf


Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse  
ST

116

11786

116

MS51859-71  Washer		Purchased	No			170	Each	64.0000	3.0000		4xsf	9/11/24 sf
---	--	-----------	----	--	--	-----	------	---------	--------	--	------	------------


Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse  
ST

64

111193

64

NAS1169-10L  Washer		Purchased	No			170	Each	30.0000	4.0000		3xsf	9/11/24 sf
--	--	-----------	----	--	--	-----	------	---------	--------	--	------	------------

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse  
ST

30

11753

30

# Picklist Print

September 22, 2009 7:42:01 AM

Page 26

Work Order ID: 52262

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS388-6-8P



Screw

Purchased

No

170

Each

13.0000

15.0000



alulay sl  
9/12/19 sl M-113470 (8x)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

111439

13

170

Each

191.0000

16.0000



9/11/2768 7x sl  
9/11/04 sl

NAS391B6P



Washer

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

191

110221

12

112195

79

112616

100

16x sl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

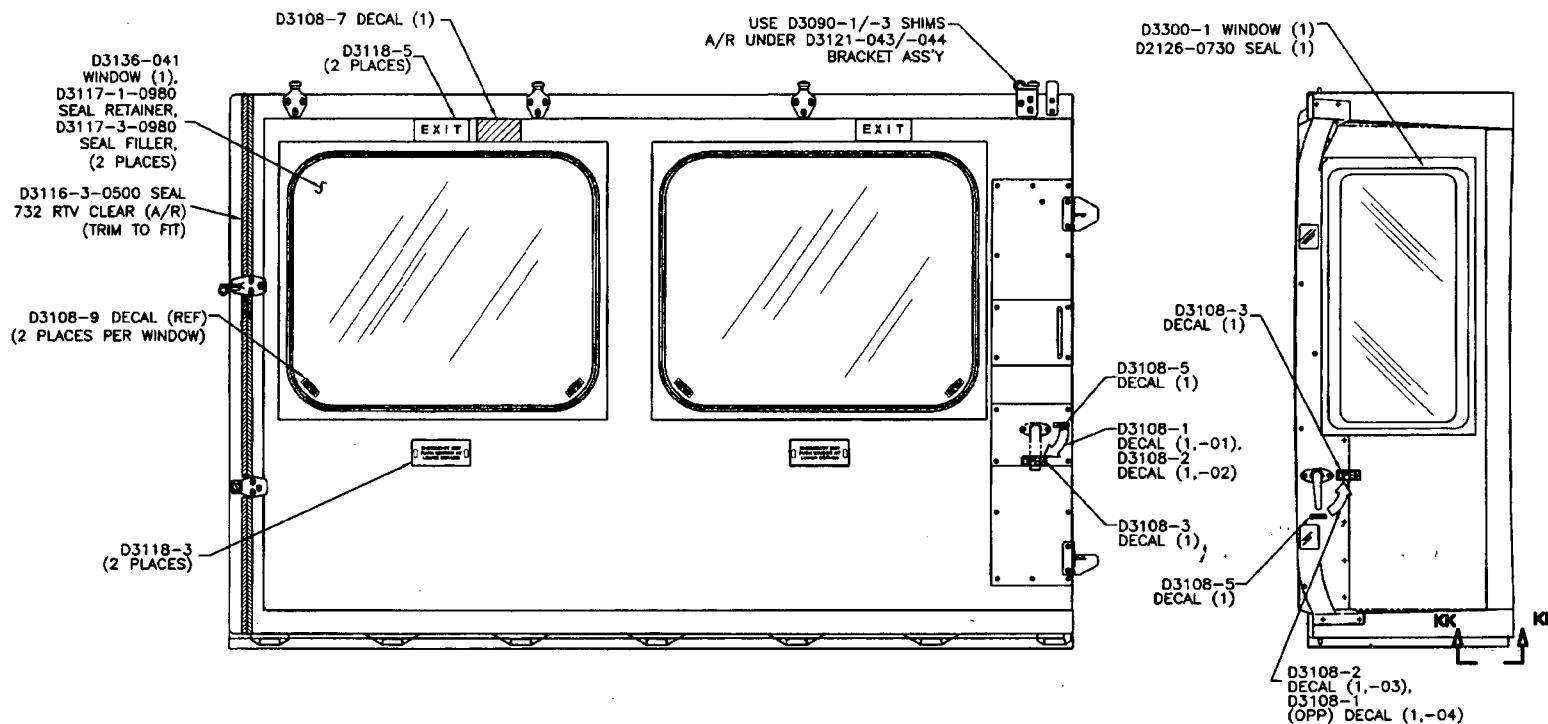
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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FIGURE 2: Decal Installation



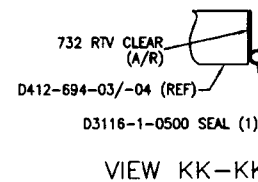
**D412-694-01 DOOR ASSY (SHOWN)**  
**D412-694-02 DOOR ASSY (OPP.)**

VIEW LOOKING • INSIDE OF DOOR

**D412-694-03 DOOR ASSY (SHOWN)**  
**D412-694-04 DOOR ASSY (OPP.)**

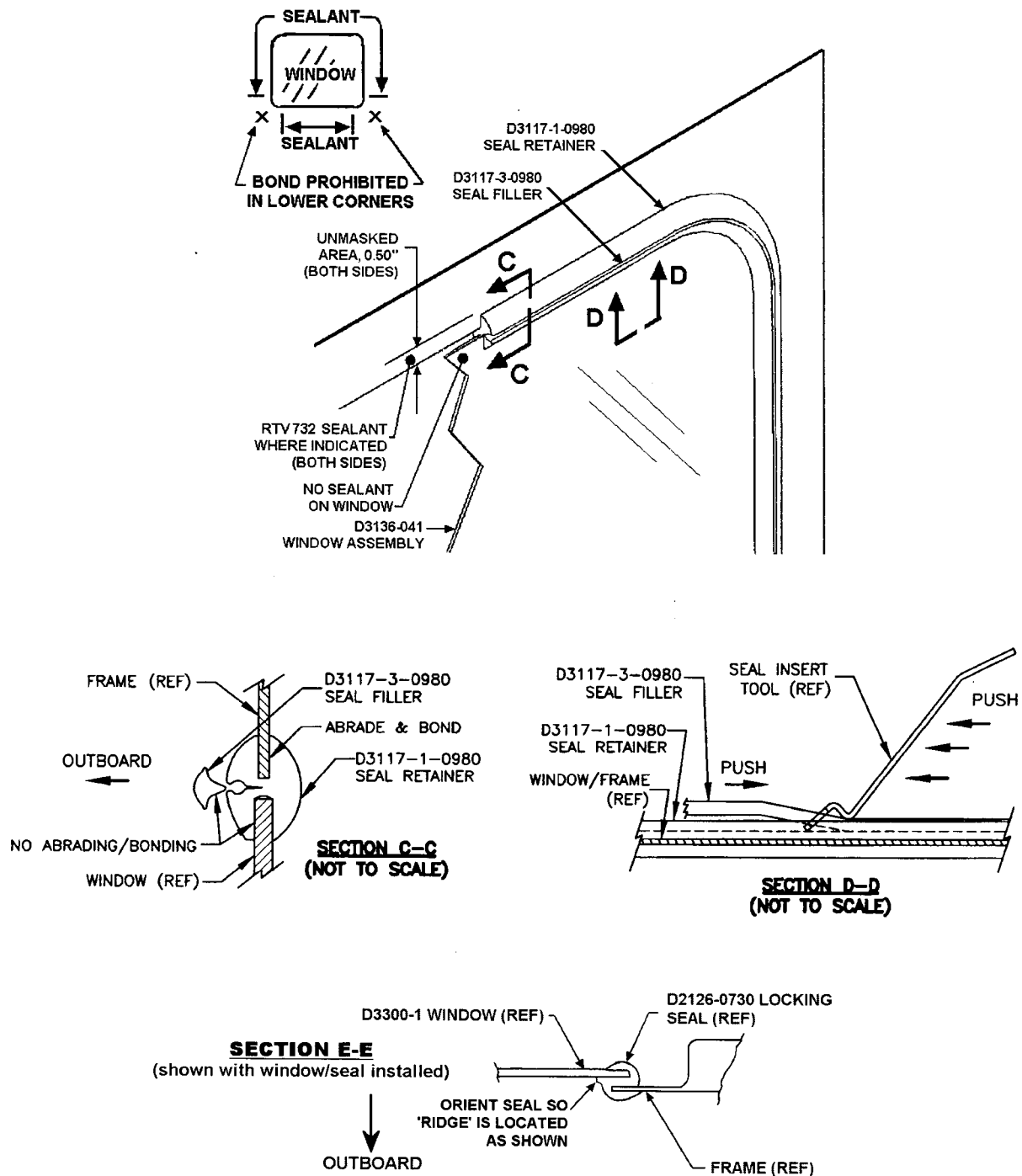
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NOTE: THE PARTS LABELLED IN THIS DIAGRAM ARE INSTALLED BY THE CUSTOMER AFTER PAINT.  
ALL OTHER PARTS COME PRE-ASSEMBLED ON THE DOOR.



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**FIGURE 3:** window/Seal Installation, (D412-694-01/02 Door Assembly)

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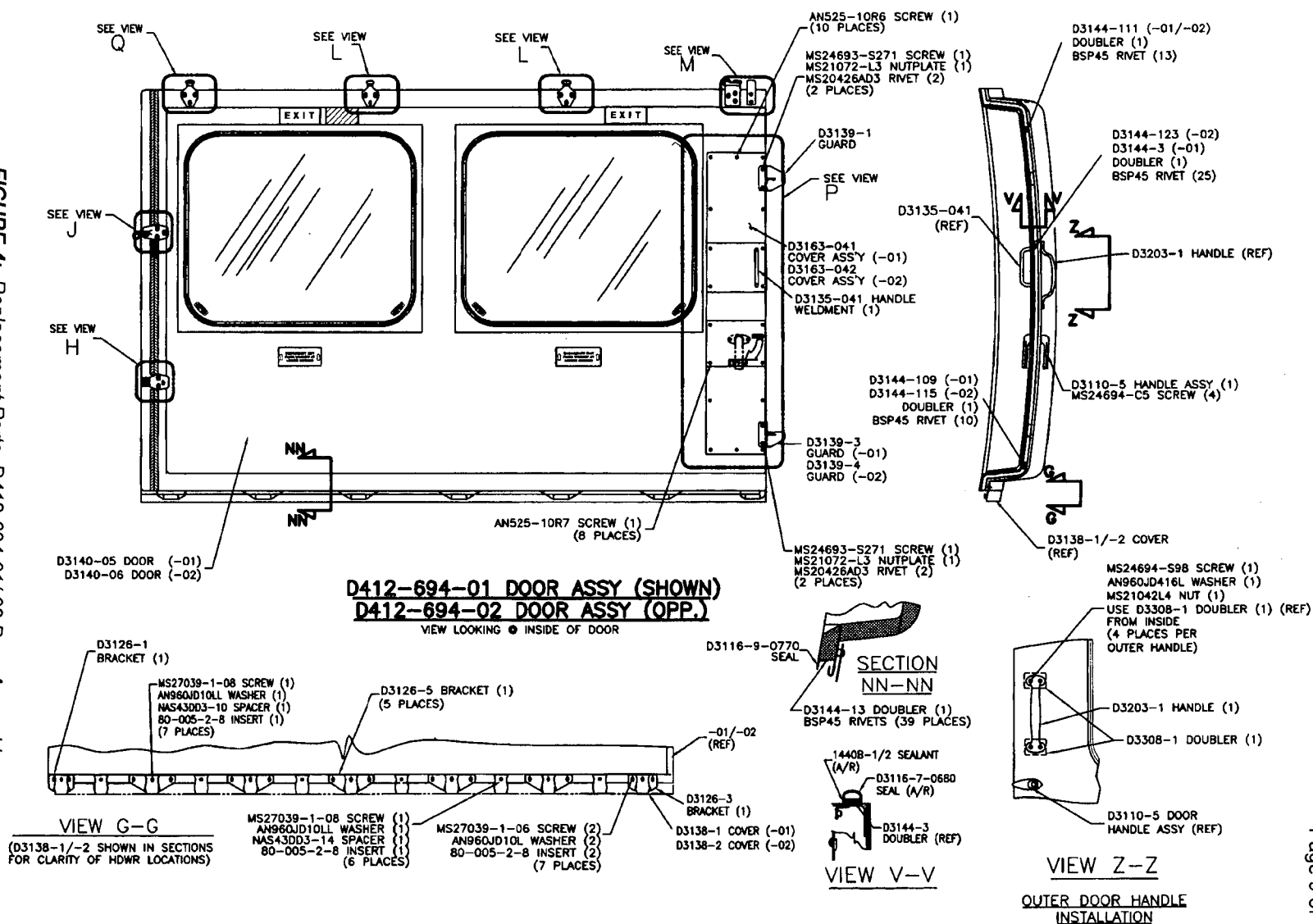
Revision: **B**  
Date: 04.10.07



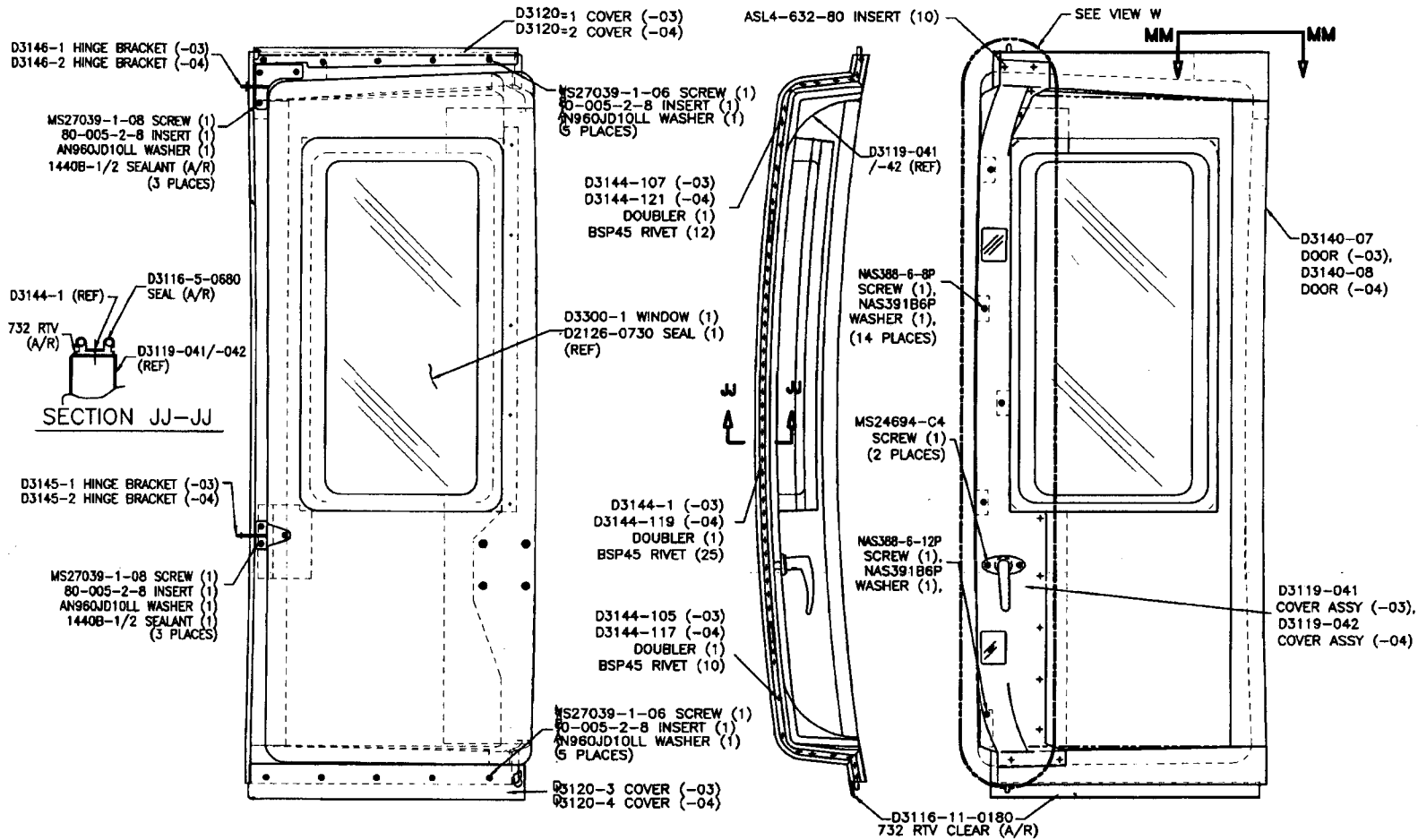
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**FIGURE 4: Replacement Parts, D412-694-01/-02 Door Assembly**



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**D412-694-03 DOOR ASSY (SHOWN)**  
**D412-694-04 DOOR ASSY (OPP)**

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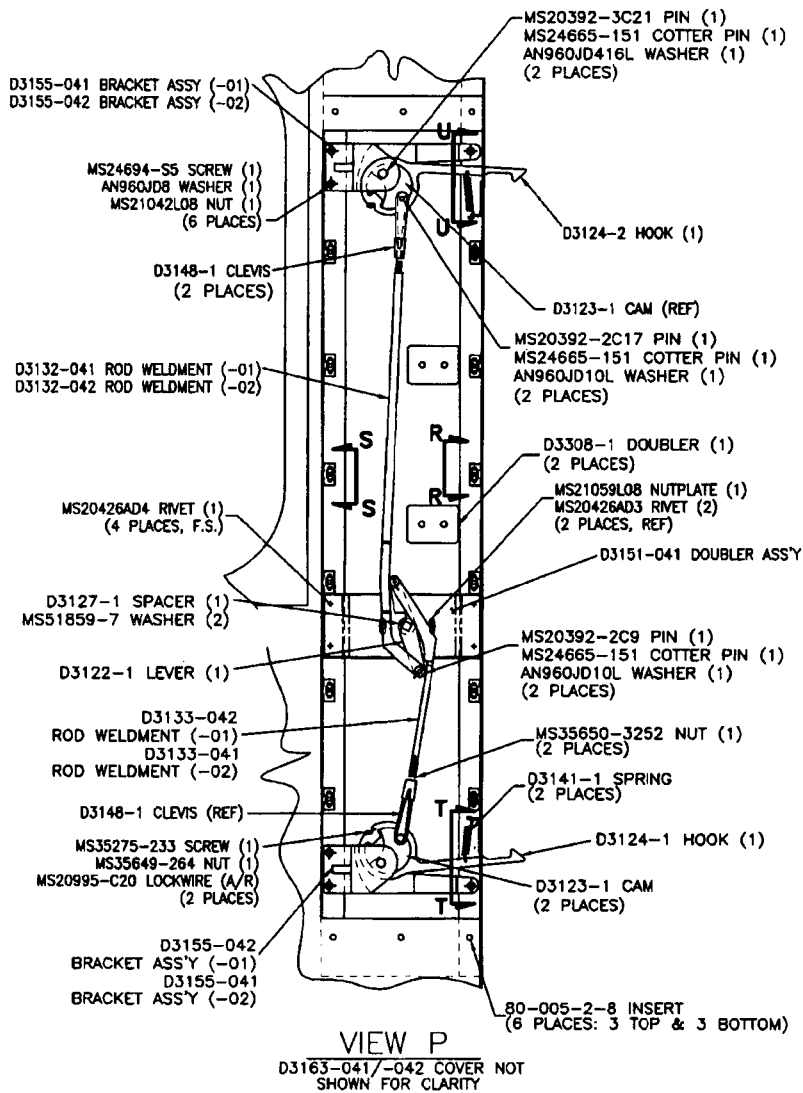


FIGURE 6: Replacement Parts, Door Assembly Details

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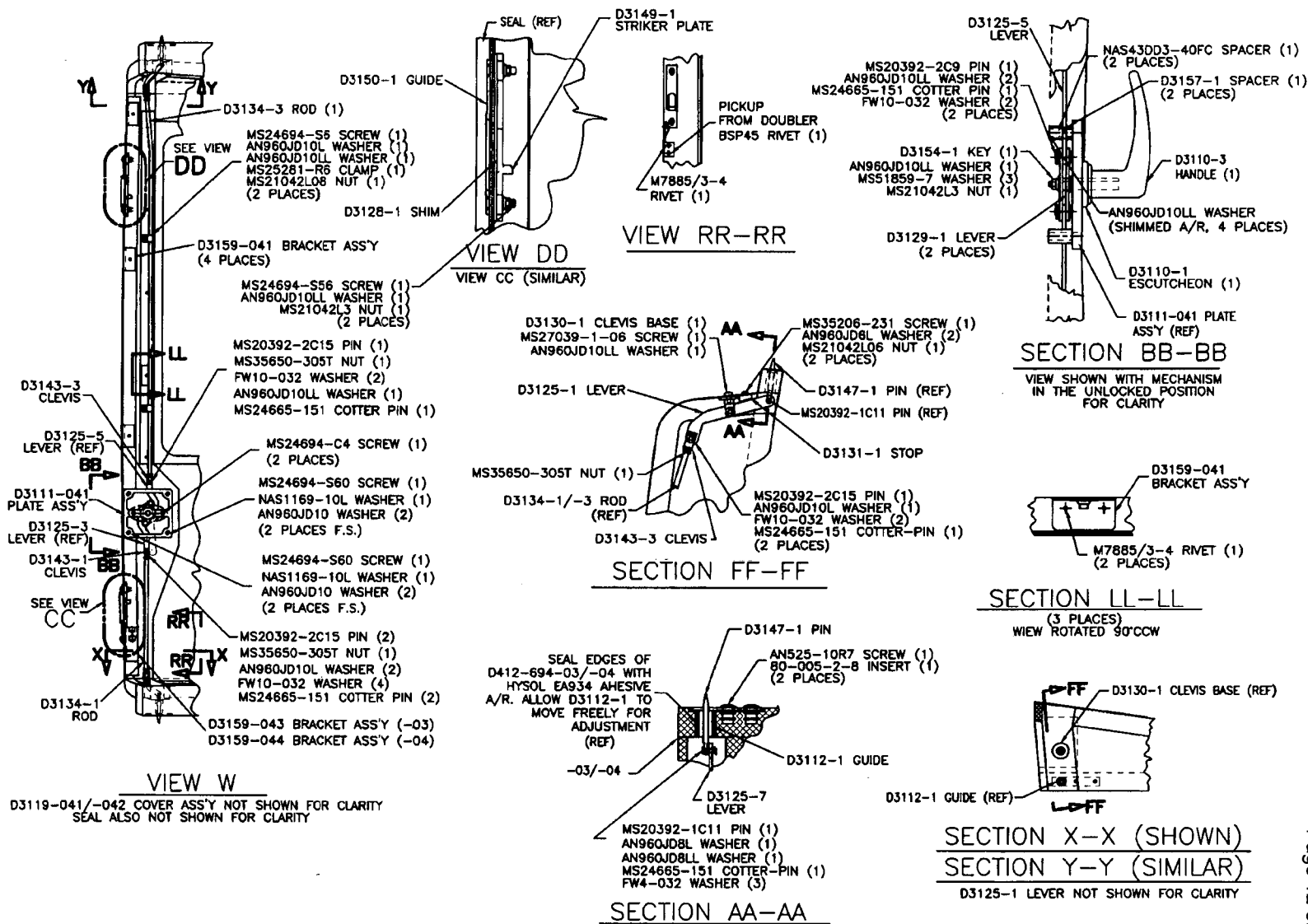
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FIGURE 7: Replacement Parts, Door Assembly Details



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Date: 04.10.07

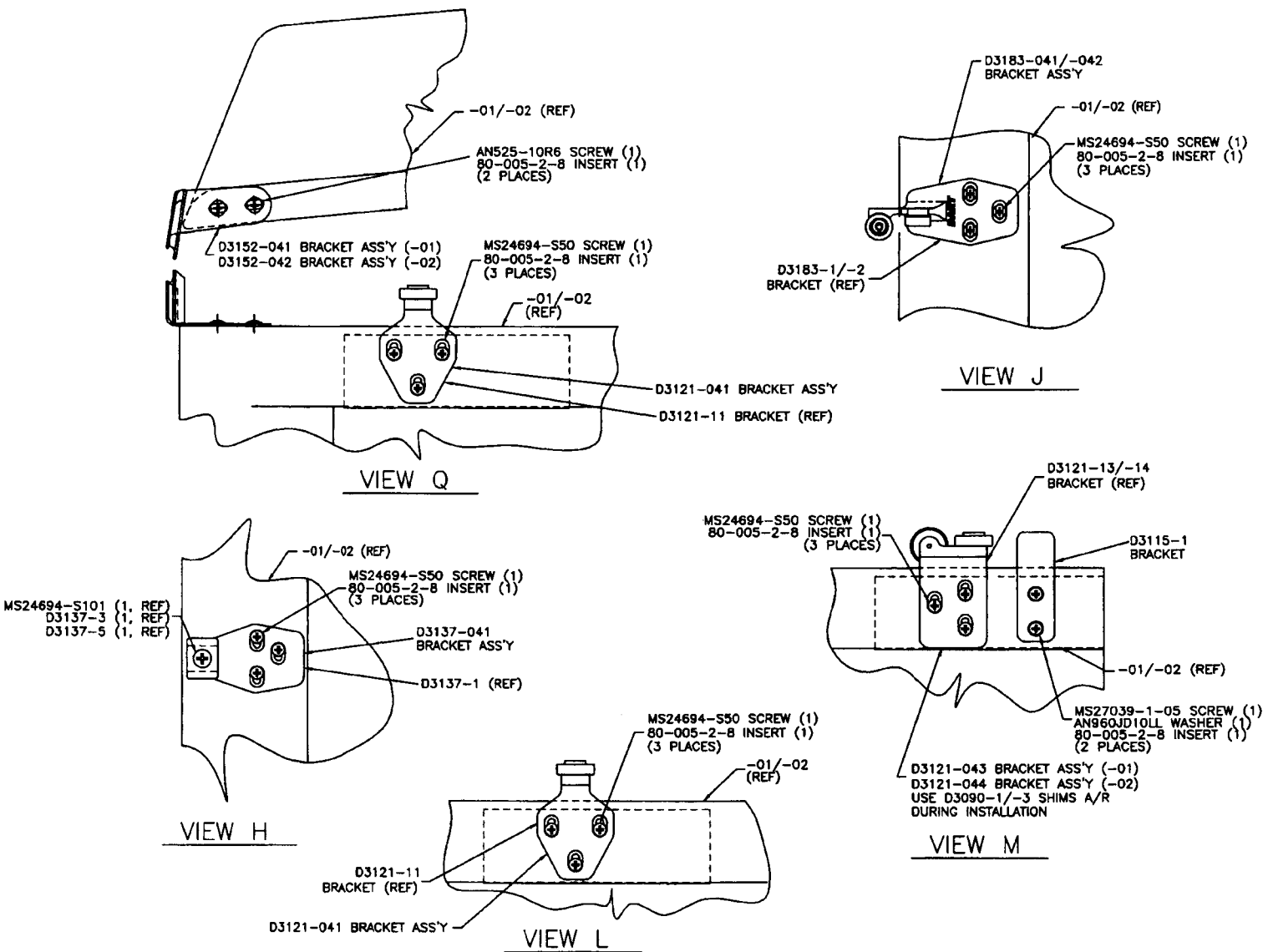
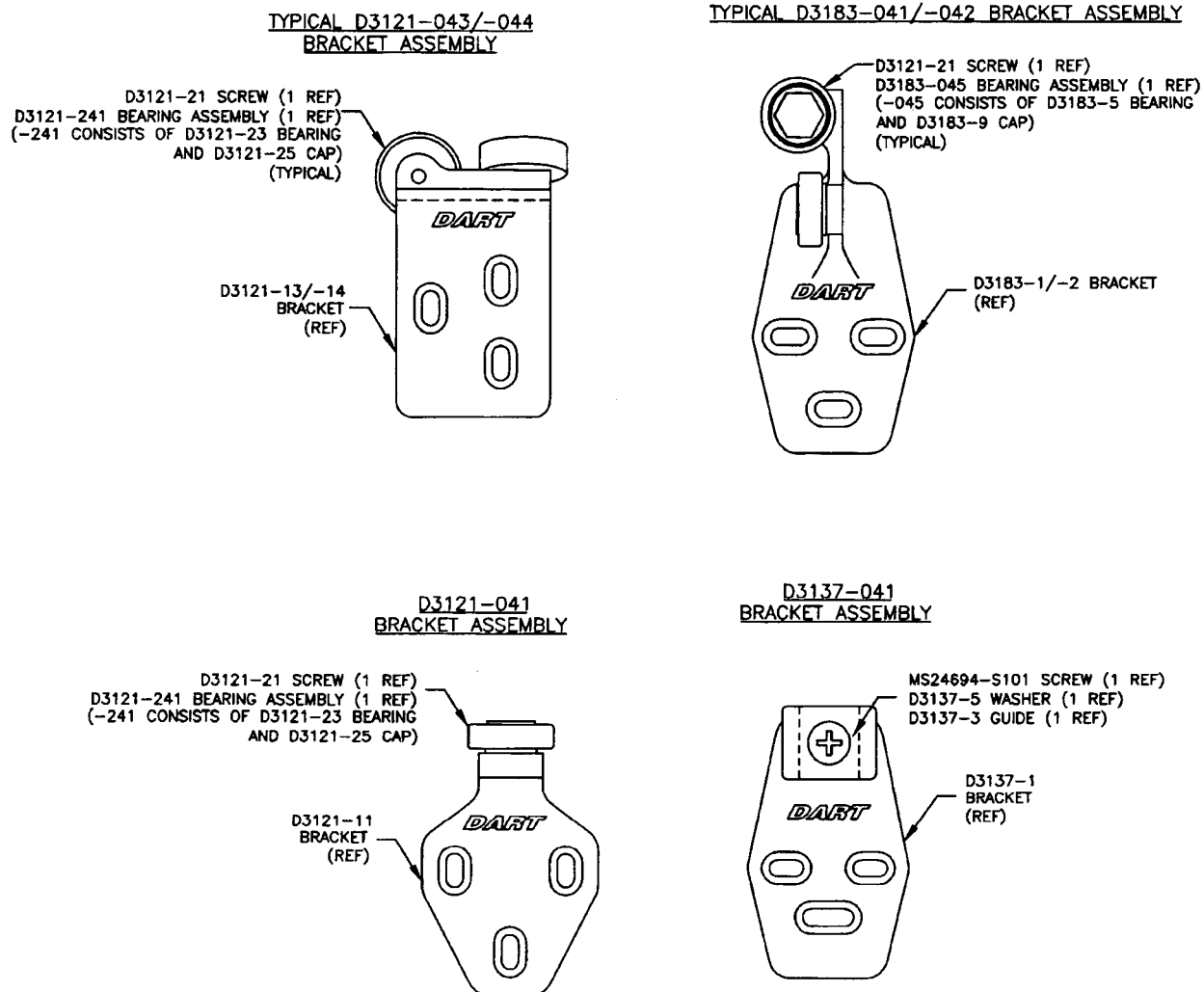


FIGURE 8: Replacement Parts, Door Assembly Details

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**FIGURE 9: Replacement Parts, D412-694-01/-02 Door Assembly**

## 6. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X								D412-694-011	SPACEDOOR™ INSTALLATION
	X							D412-694-013	PANEL INSTALLATION (OPTIONAL)
4		X						D412-694-015	REPLACEMENT WINDOW KIT
			X					D412-694-017	BEARING OVERHAUL KIT
1				X				D412-694-01	DOOR ASSEMBLY
1					X			D412-694-02	DOOR ASSEMBLY
1						X		D412-694-03	DOOR ASSEMBLY
1							X	D412-694-04	DOOR ASSEMBLY
2								D2126-0730	SEAL
4								D3090-1	SHIM
4								D3090-3	SHIM
2								D3108-1	DECAL
2								D3108-2	DECAL
4								D3108-3	DECAL
4								D3108-5	DECAL
2								D3108-7	DECAL
						1	1	D3110-1	ESCUTCHEON
						1	1	D3110-3	HANDLE
				1	1			D3110-5	HANDLE ASSEMBLY
						1	1	D3111-041	PLATE ASSEMBLY
						2	2	D3112-1	GUIDE
						1	1	D3113-1	SPRING
						1	1	D3114-1	PIVOT
				1	1			D3115-1	BRACKET
2								D3116-1-0500	SEAL
						1	1	D3116-11-0180	SEAL
2								D3116-3-0500	SEAL
						1	1	D3116-5-0680	SEAL
				1	1			D3116-7-0680	SEAL
				1	1			D3116-9-0770	SEAL
		1						D3117-1-0980	SEAL RETAINER
		1						D3117-3-0980	SEAL FILLER
4								D3118-3	SIGN ASSEMBLY
4								D3118-5	SIGN ASSEMBLY
						1		D3119-041	COVER ASSEMBLY
							1	D3119-042	COVER ASSEMBLY
						1		D3120-1	COVER
							1	D3120-2	COVER
						1		D3120-3	COVER
							1	D3120-4	COVER
				3	3			D3121-041	BRACKET ASSEMBLY ("ROLLER")
				1				D3121-043	BRACKET ASSEMBLY ("ROLLER")
					1			D3121-044	BRACKET ASSEMBLY ("ROLLER")
			7					D3121-21	SCREW

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Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
			5					D3121-241	BEARING ASSEMBLY
				1	1			D3122-1	LEVER
				2	2			D3123-1	CAM
				1	1			D3124-1	HOOK
				1	1			D3124-2	HOOK
						1	1	D3125-1	LEVER
						1	1	D3125-3	LEVER
						1	1	D3125-5	LEVER
						1	1	D3125-7	LEVER
				1	1			D3126-1	BRACKET ("SLIDER")
				1	1			D3126-3	BRACKET ("SLIDER")
				5	5			D3126-5	BRACKET ("SLIDER")
				1	1			D3127-1	SPACER
						1	1	D3128-1	SHIM
						2	2	D3129-1	LEVER
						2	2	D3130-1	CLEVIS BASE
						1	1	D3131-1	STOP
				1				D3132-041	ROD WELDMENT
					1			D3132-042	ROD WELDMENT
					1			D3133-041	ROD WELDMENT
				1				D3133-042	ROD WELDMENT
						1	1	D3134-1	ROD
						1	1	D3134-3	ROD
				1	1			D3135-041	HANDLE WELDMENT
		1						D3136-041	WINDOW ASSEMBLY
				2				D3137-041	BRACKET ASSEMBLY ("ROLLER")
			1					D3137-3	GUIDE
			1					D3137-5	WASHER
				1				D3138-1	COVER
					1			D3138-2	COVER
				1	1			D3139-1	GUARD
				1				D3139-3	GUARD
					1			D3139-4	GUARD
				1				D3140-05	DOOR
					1			D3140-06	DOOR
						1		D3140-07	DOOR
							1	D3140-08	DOOR
				2	2			D3141-1	SPRING
						1	1	D3143-1	CLEVIS
						3	3	D3143-3	CLEVIS
						1		D3144-1	DOUBLER
						1		D3144-105	DOUBLER
						1		D3144-107	DOUBLER
				1				D3144-109	DOUBLER
				1	1			D3144-111	DOUBLER
					1			D3144-115	DOUBLER
							1	D3144-117	DOUBLER
							1	D3144-119	DOUBLER



Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
					1		1	D3144-121	DOUBLER
					1			D3144-123	DOUBLER
				1	1			D3144-13	DOUBLER
				1				D3144-3	DOUBLER
						1		D3145-1	HINGE BRACKET
							1	D3145-2	HINGE BRACKET
						1		D3146-1	HINGE BRACKET
							1	D3146-2	HINGE BRACKET
						2	2	D3147-1	PIN
				2	2			D3148-1	CLEVIS
						2	2	D3149-1	STRIKER PLATE
						2	2	D3150-1	GUIDE
				1	1			D3151-041	DOUBLER ASSEMBLY
				1				D3152-041	BRACKET ASSEMBLY
					1			D3152-042	BRACKET ASSEMBLY
	1							D3153-11	PANEL
	1							D3153-12	PANEL
	1							D3153-13	PANEL
	1							D3153-14	PANEL
	1							D3153-15	PANEL
	1							D3153-16	PANEL
						1	1	D3154-1	KEY
				1	1			D3155-041	BRACKET ASSEMBLY
				1	1			D3155-042	BRACKET ASSEMBLY
				2	2			D3156-1	BRACKET
						2	2	D3157-1	SPACER
						3	3	D3159-041	BRACKET ASSEMBLY
						1		D3159-043	BRACKET ASSEMBLY
							1	D3159-044	BRACKET ASSEMBLY
				12	12			D3162-041	BRACKET ASSEMBLY
				1				D3163-041	COVER ASSEMBLY
					1			D3163-042	COVER ASSEMBLY
				1				D3183-041	BRACKET ASSEMBLY ("ROLLER")
					1			D3183-042	BRACKET ASSEMBLY ("ROLLER")
			2					D3183-045	BEARING ASSEMBLY
				1	1			D3203-1	HANDLE ASSEMBLY
2								D3300-1	WINDOW
				2	2			D3308-1	DOUBLER
				55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
	60							A6K75	RIVNUT
				10	10			AN525-10R6	SCREW
				8	8	4	4	AN525-10R7	SCREW
						8	8	AN960JD10	WASHER
				18	18	4	4	AN960JD10L	WASHER
				13	13	32	32	AN960JD10LL	WASHER
				6	6			AN960JD416L	WASHER
						4	4	AN960JD6L	WASHER
				6	6			AN960JD8	WASHER
						2	2	AN960JD8L	WASHER

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Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
						2	2	AN960JD8LL	WASHER
						10	10	ASL4-632-80	INSERT
				87	87	47	47	BSP45	RIVET
						14	14	FW10-032	WASHER
						6	6	FW4-032	WASHER
				12	12			M7885/2-4	RIVET (OR CR3213-4-3)
						3	3	M7885/3-4	RIVET (OR CR3212-4-3)
						2	2	MS20392-1C11	PIN
						5	5	MS20392-2C15	PIN
				2	2			MS20392-2C17	PIN
				2	2	2	2	MS20392-2C9	PIN
				2	2			MS20392-3C21	PIN
				8	8			MS20426AD3	RIVET
				20	20			MS20426AD4	RIVET
				A/R	A/R			MS20995-C20	LOCKWIRE
						6	6	MS21042L06	NUT
				6	6	2	2	MS21042L08	NUT
						5	5	MS21042L3	NUT
				4	4			MS21042L4	NUT
				4	4			MS21072-L3	NUTPLATE
				6	6	9	9	MS24665-151	COTTER PIN
				4	4			MS24693-S271	SCREW
						2	2	MS24694-C4	SCREW
				4	4			MS24694-C5	SCREW
			1					MS24694-S101	SCREW
				6	6			MS24694-S5	SCREW
				18	18			MS24694-S50	SCREW
						4	4	MS24694-S56	SCREW
						2	2	MS24694-S6	SCREW
						4	4	MS24694-S60	SCREW
				4	4			MS24694-S98	SCREW
						2	2	MS25281-R6	CLAMP
				2	2	2	2	MS27039-1-05	SCREW
				14	14	12	12	MS27039-1-06	SCREW
				13	13	6	6	MS27039-1-08	SCREW
						2	2	MS35206-231	SCREW
				2	2			MS35275-233	SCREW
				2	2			MS35649-264	NUT
						4	4	MS35650-305T	NUT
				2	2			MS35650-3252	NUT
				2	2	3	3	MS51859-7	WASHER
						4	4	NAS1169-10L	WASHER
						1	1	NAS388-6-12P	SCREW
	60					14	14	NAS388-6-8P	SCREW
	60					15	15	NAS391B6P	WASHER
				7	7			NAS43DD3-10	SPACER
				6	6			NAS43DD3-14	SPACER
						2	2	NAS43DD3-40	SPACER

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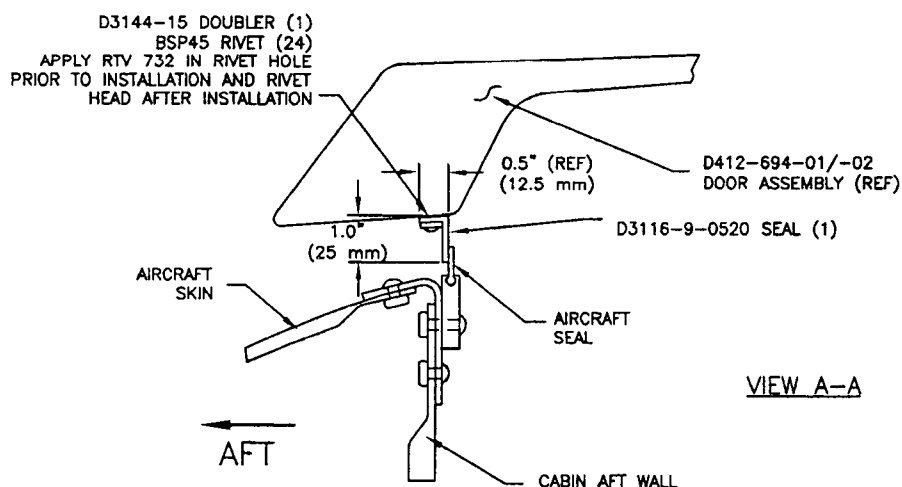
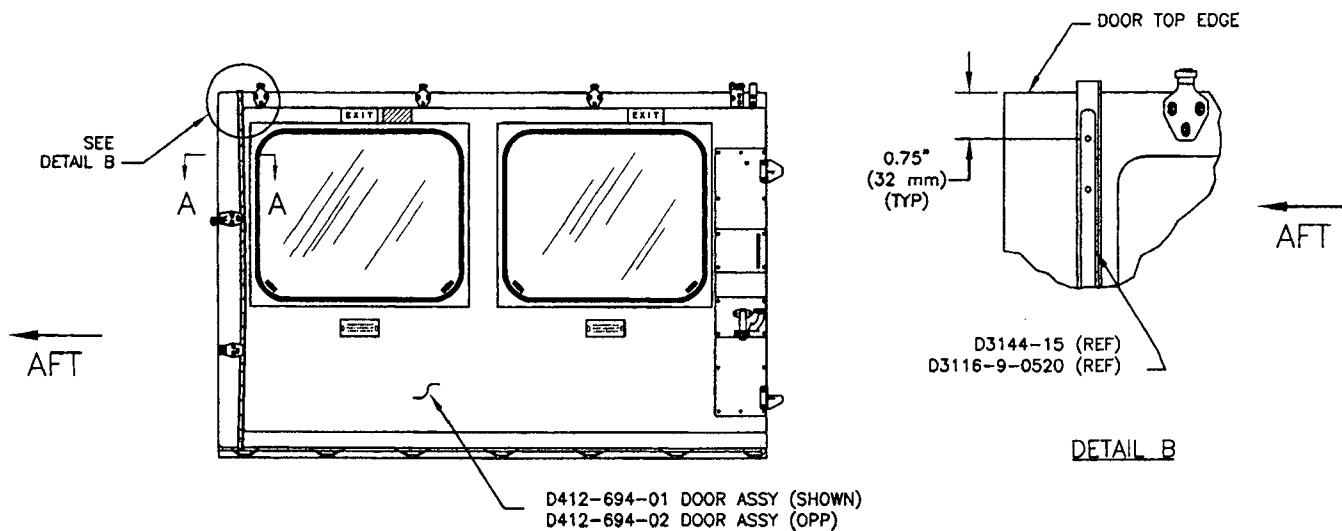
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DATE 05.09.26	TITLE SEAL KIT		SCALE NTS



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<b>APPROVED</b>	
BY:	<i>[Signature]</i> D. SHEPHERD (DE # 02)
DATE:	05.09.26
CERT. NO.:	SH05-10
ISSUE NO.:	1

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DATE 05.11.11		TITLE BRACKET MODIFICATION KIT	SCALE NTS
A	05.11.11	NEW ISSUE	

## **DART SERVICE INSTRUCTION**

**TO AMEND IIN-D412-694 REV. B**

REF. CANADIAN STC: SH05-10

REF. FAA STC: SR02086NY

For the D412-694-01/-02 Door Assembly, if the travel of the D3110-5 Handle Assembly interferes with the D3133-041/-042 Rod Weldment or nutplate on the D3162-041 Bracket Assembly, it is acceptable to install the DSI 9314-011 Kit to correct this problem. The DSI 9314-011 Kit may be installed on D412-694-01/-02 Door Assemblies at CHG003 or earlier change numbers. This modification should be performed per the procedure below and figures 1 & 2 of this document.

**CUSTOMERS WITH EARLY MODEL D412-694-011 KITS CAN PROCURE THE DSI 9314-011 KIT FROM DART TO DO THIS MODIFICATION.**

-Qty	Part Number	Description
X	DSI 9314-011	BRACKET MODIFICATION KIT
4	D3162-043	BRACKET ASSEMBLY
4	D3162-044	BRACKET ASSEMBLY
1	D3163-041	COVER ASSEMBLY
1	D3163-042	COVER ASSEMBLY
30	BSP45	RIVET
8	M7885/2-4-3	RIVET
8	MS20426AD4-7	RIVET

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY:

D. SHEPHERD (DE # 02)

DATE: 05.11.11

CERT. NO.: SH05-10

ISSUE NO.: 1

### **PROCEDURE:**

- 1) From the D412-694-01/-02 Door Ass'y, remove D3163-041/-042 Cover Assembly and enough of the rivets securing the D3144-3 Doubler (-01 Door Ass'y) or D3144-123 Doubler (-02 Door Ass'y) so that the rivets attaching the D3162-041 Brackets can be accessed (see Figure 2).
- 2) Remove D3162-041 Bracket Assembly in 4 places as shown in Figure 1.
- 3) Transfer holes from the existing D3163-041/-042 Cover Assembly to the replacement cover assembly except do not transfer the 4 holes used to secure the D3162-041 Bracket in step 2 of this service instruction.
- 4) Locate holes in D3163-041/-042 as shown in Figure 2 to help properly locate D3162-043/-044 as shown in Figure 1. Transfer drill the 2 existing #30 diameter holes (used to fasten the removed D3162-041) from the door to each D3162-043/-044 Bracket Ass'y as shown in Figure 1. Touch up with Alodine per MIL-C-5541 and match original finish.
- 5) Install D3162-043/-044 Bracket Assembly as shown in Figure 1. If necessary fill any holes remaining that would be visible from the exterior of the door with Hysol EA934NA or equivalent. Touch up with Grey Primer 1144-S or equivalent and match original finish.
- 6) Re-install D3144-123/D3144-3 Doubler using BSP45 rivets.
- 7) Transfer D3139-1/-3/-4 Guard, D3135-041 Handle Weldment & D3110-5 Handle Ass'y and hardware from existing cover to the new D3163-041/-042 Cover Assembly per IIN-D412-694.
- 8) Re-install D3163-041/-042 Cover Assembly per IIN-D412-694.

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DATE 05.11.11	TITLE BRACKET MODIFICATION KIT		SCALE NTS

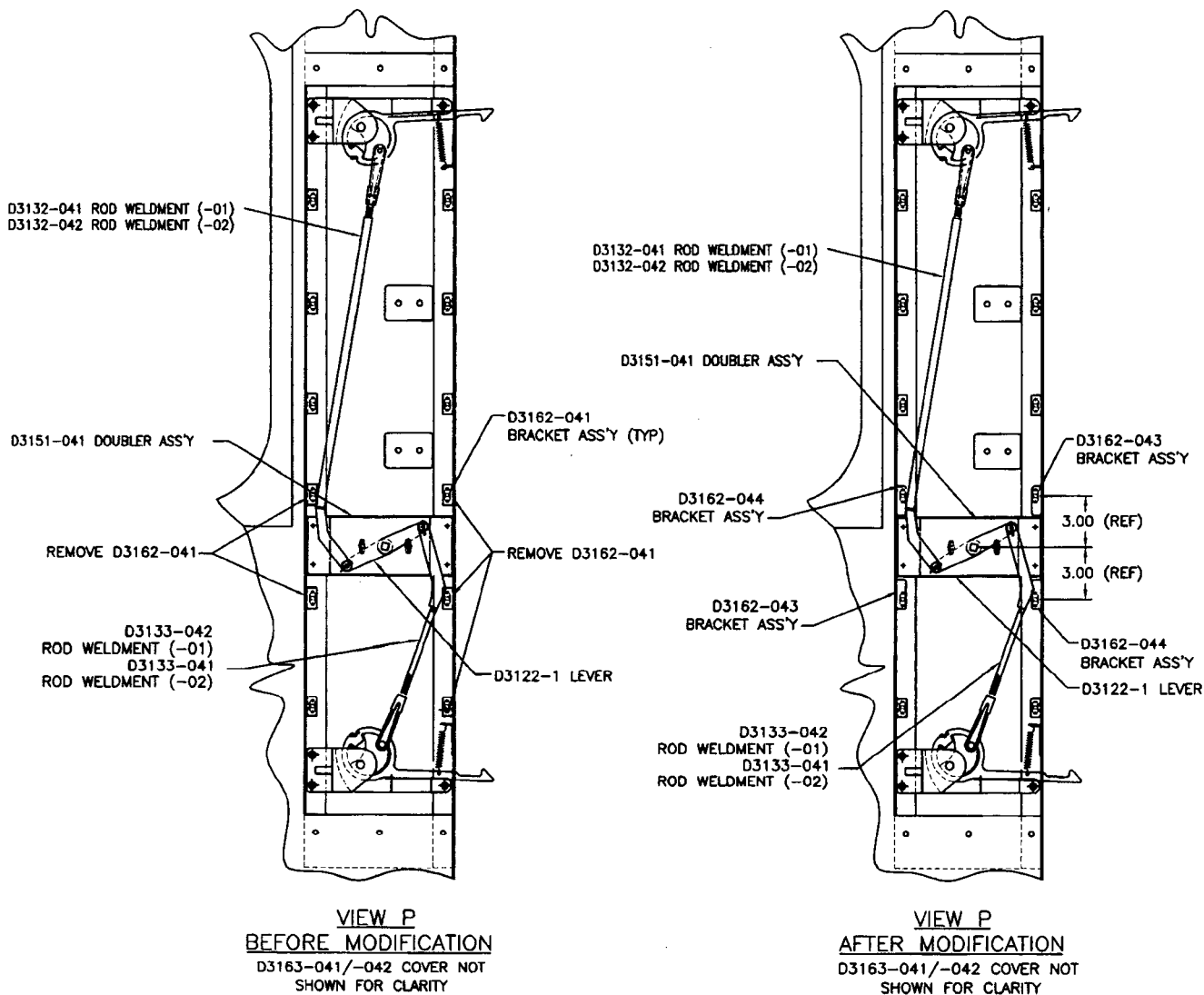


FIGURE 1

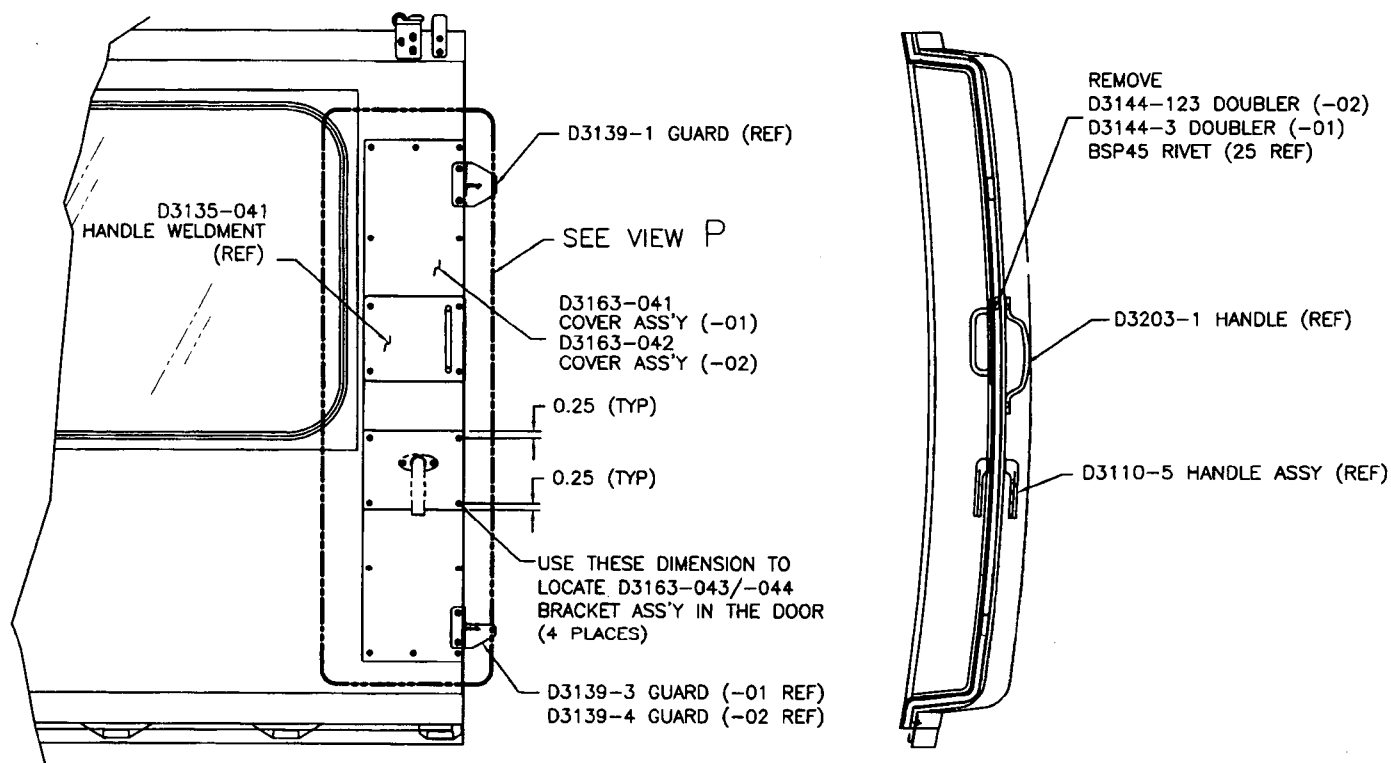
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DATE 05.11.11	TITLE BRACKET MODIFICATION KIT		SCALE NTS



D412-694-01 DOOR ASSY (SHOWN)  
D412-694-02 DOOR ASSY (OPP.)  
VIEW LOOKING • INSIDE OF DOOR

FIGURE 2

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i> D. SHEPHERD (DE # 02)
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DATE 05.12.12		TITLE PART SUBSTITUTION	SCALE NTS
A	05.12.12	NEW ISSUE	

## **DART SERVICE INSTRUCTION**

**TO AMEND INSTALLATION INSTRUCTIONS D412-694 REV. B**

REF. CANADIAN STC: SH05-10

REF. FAA STC: SR02086NY

ON D412-694-011 AT CHG 005 OR LATER

**D3137-045 BRACKET ASSEMBLY**

REPLACES

**D3137-041 BRACKET ASSEMBLY**

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b>	
BY:	D. SHEPHERD (DE # 02)
DATE: 05.12.12	
CERT. NO.: SH05-10	
ISSUE NO.: 1	

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DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>#</b>	DRAWING NO. DSI 9363	REV. A SHEET 1 OF 1
DATE 07.01.19		TITLE SHIM KIT	SCALE NTS
A	07.01.19	NEW ISSUE	

## **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-694 REV. B AND INSTRUCTIONS FOR CONTINUED

AIRWORTHINESS ICA-D412-694 REV. 1

REF. CANADIAN STC: SH05-10

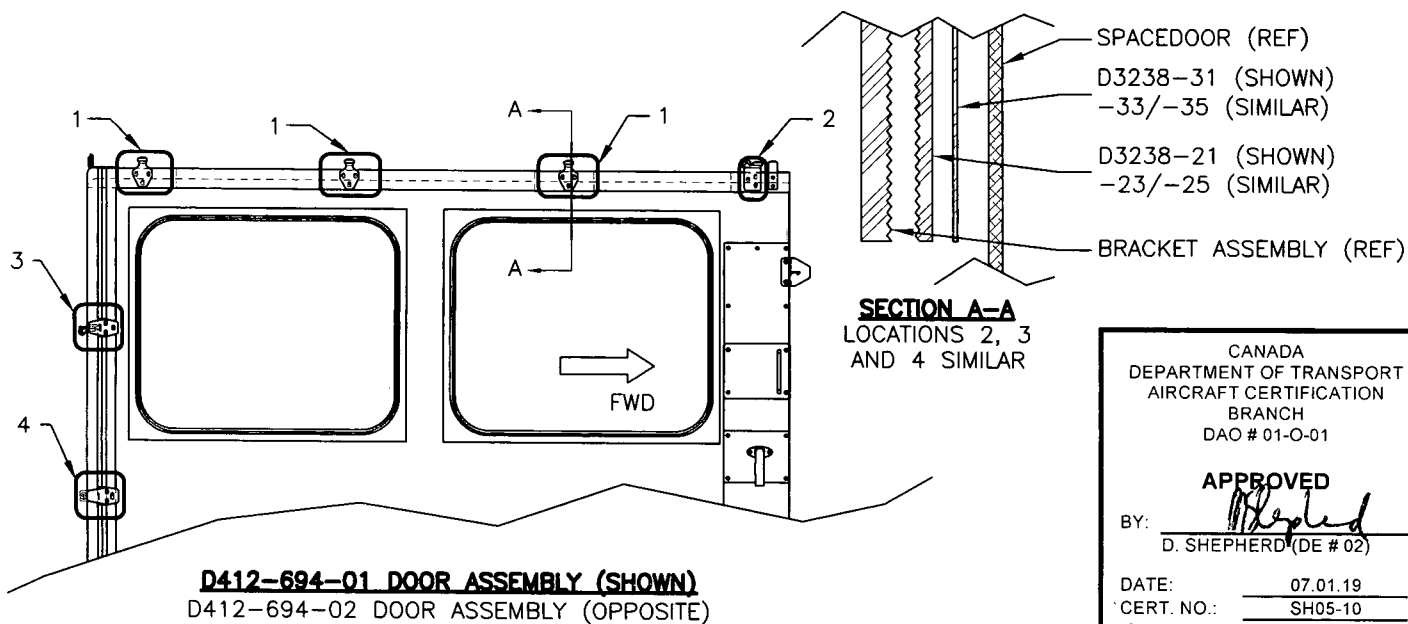
REF. FAA STC: SR02086NY

Dart has created the optional DSI-9363-011 Shim Kit that may be installed between the D3121-041/-043/-044, D3183-041/-042 and D3137-041 Bracket Assemblies and the Spacedoor™ to improve grip between the Bracket Assemblies and the Spacedoor™. This kit may be installed as a replacement for or in addition to the AN960JD10 Washers and/or the D3090-1/-3 Shims used to shim the Bracket Assemblies as described in the Installation Instructions.

The serrated faces of the D3238-21/-23/-25 Plates should be installed against the serrated faces of the Bracket Assemblies to ensure positive locking as shown in **Section A-A**. The D3238-31/-33/-35 Plates, the AN960JD10 Washers and the D3090-1/-3 Shims can be installed as required between the D3238-21/-23/-25 Plates and the Spacedoor™ to achieve good door alignment.

The Table and Figure below show the location, the quantity and the part number of each Plate and the corresponding Bracket Assemblies on the Spacedoor™.

Qty	Part Number	Description	Used to Shim Bracket Assembly P/Ns	Location
X	DSI-9363-011	SHIM KIT		
6	D3238-21	PLATE	D3121-041	1
12	D3238-31	PLATE	D3121-041	1
2	D3238-23	PLATE	D3121-043/-044	2
4	D3238-33	PLATE	D3121-043/-044	2
4	D3238-25	PLATE	D3183-041/-042, D3137-041	3, 4
8	D3238-35	PLATE	D3183-041/-042, D3137-041	3, 4



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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

## PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13236
Customer #	DART

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #		
19/11/2009	22/09/2009	6041	Chantal Lavoie	PO10435			
Order Qty	B.O. Qty	Current Ship	Item #	Item Description			
1	0	1	DKC135-0019	LINE #1 D3140-06 Door Right Non Assy ( Grosse ) DWG D3140 REV. F Job: 22074			
1	0	1	DKC135-0020	LINE #2 D3140-08 Door Right Non Assy ( Petite ) DWG D3140 REV. F Job: 22074			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

  
Quality department



AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2009-09-22 11:40:28  
Utilisateur: marc dubé

## Feuille de Procédé

Client : DART US DART AEROSPACE LTD  
Numéro Job : 22074  
Numéro Soumission : 3407  
Numéro B.A. :  
Date : 2009-09-22 No. B.V. :  
Dernière Rev. : NC  
Rem. fois : - - Type :  
Job précédente :  
Écrit par :  
Vérifié & Approuvé par :  
Commentaires : N° de pièce Client: D3140-06/-08

Nom Dessin : DOOR KIT D.  
Numéro Article : DKC135-0019/-0020  
Numéro Dessin : D3140  
Projet Numéro : DK-359  
Révision dessin : F  
Matériel : Fibercote E-761  
Date Dûe : 2009-09-29 Qté: 1 UdM: UNITE

Process Sheet Rév.: 01 Remplacer le Doubler Kit N° AAC1613 par  
des N° de détails AAC1630, AAC1631, AAC1633, AAC1634,  
AAC1636, AAC1637, AAC1638, AAC1640, AAC1642, AAC1643 &  
AAC1645

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	OUTILLAGE	Outillage nécessaire pour la job



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Moule N° B30-23000-01T  
Patron de découpe N° B30-23000-57T  
Patron de découpe N° B30-23000-61T  
Patron de découpe N° B30-23000-63T  
Patron de découpe N° B30-23000-71T  
Patron de découpe N° B30-23000-73T  
Patron de découpe N° B30-23000-75T  
Patron de découpe N° B30-23000-77T  
Patron de découpe N° B30-23000-79T  
Gabarit de taillage N° B30-23000-06T ( 2 pièce ) et N° B30-2300-03T  
Forme de silicone N° B30-23000-08T

2.0 AAC0854 Frekote #700-NC

Commentaire Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)  
Frekote #700-NC N° de Lot: 1-7095-1

3.0 PRÉPARATION Préparation du moule



Commentaire Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs

Faire la préparation du moule selon IF135-0002 et IG 0009

Date: Mardi, 2009-09-22 11:40:28

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22074

Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.: Machine ou Opération: Description :

4.0 AMB0211 Epoxy prepreg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)

Epoxy prepreg E-761 style 7781

N° de Lot: 1-24937-1

5.0 DECOUPE Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi\*. (7 Paquet = 24.5 verges)

Quantité: 1

Date: 6-10-09

Sceau: NT.



6.0 DRAPAGE

Drapage



Commentair Setup: 0.00Hrs/ Run: 720.0000Hrs Total Run : 720.0000Hrs

Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0002

Quantité: 1

Date: 6-10-09

Sceau: NT.



7.0 AC0883

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

8.0 AC0884 Wrighton 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

9.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

10.0 AC0882 Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

11.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

12.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le bagging sur la pièce selon IF135-0002 et IG 0012

Quantité: 1

Date: 7-10-09

Sceau: NT.



13.0 CUISSON

Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20 N° de Cuisson: 6119

Date: Mardi, 2009-09-22 11:40:28  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22074

Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.: Machine ou Opération:

Description:

Quantité: 1 Date: 8/10/09 Sceau:

14.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Retirer le montage cuisson et faire les retouches de la pièces afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: 1 Date: 9/10/09 Sceau:

15.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1 Date: 14 oct 09 Sceau:

16.0

AAC1618

Rohacell 71S 1"thick 49.2" x 98.4" plain

Commentair Qty.: 2.00 FEUILLE(s)/Unit Total : 2.00 FEUILLE(s)  
Rohacell 71S 1"thick 49.2" x 98.4" plain N° de Lot: 1-24967-1 et 1-25513-1

17.0

DECOUPE

Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Faire la découpe des pièce de mousse structurales (Rohacell) sur la scie à ruban selon IF135-0002.

Quantité: 1 Date: 18/10/09 Sceau:

18.0

SÉCHAGE/ ANEAL

Séchage / Annealing



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le séchage du Rohacell selon IF135-0002 et les information du manufacturier. N° de

Cuisson: 6133

Quantité: 1 Date: 26/10/09 Sceau:

Date: Mardi, 2009-09-22 11:40:28  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 22074

Nom Dessin: DOOR KIT  
Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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19.0	AAC0560	PF-7035C supp.. film epoxy adhesive
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Commentair Qty.: 55.00 PIED CARRE(s)/Unit Total : 55.00 PIED CARRE(s)  
PF-7035C supp.. film epoxy adhesive N° de Lot: 1-6534-1

20.0	AAC0559	Core splice adhesive MA560.048
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Commentair Qty.: 5.00 PIED CARRE(s)/Unit Total : 5.00 PIED CARRE(s)  
Core splice adhesive MA560.048 N° de Lot: 1-7154-1

21.0	AAC0563	Epoxy Epocast 87269-A/B (4*2.9)
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Commentair Qty.: 1 KIT(s)/Unit Total : 1 KIT(s)  
Epoxy Epocast 87269-A/B (4\*2.9) N° de Lot: AD-Tek P-17 1-24938-1

22.0	<del>AAC1630</del>	N° D3140-09, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
D3140-10 N° ~~D3140-09~~, Doubler N° de Lot: 1-25506-11

23.0	AAC1631	N° D3140-87, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
N° D3140-87, Doubler N° de Lot: 1-25506-4

24.0	AAC1633	N° D3140-92, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
N° D3140-92, Doubler N° de Lot: 1-25506-5

25.0	AAC1634	N° D3140-95, Doubler
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Commentair Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s)  
N° D3140-95, Doubler N° de Lot: 1-25506-6

26.0	AAC1636	N° D3140-98, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
N° D3140-98, Doubler N° de Lot: 1-25506-7

27.0	AAC1637	N° D3140-99, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
N° D3140-99, Doubler N° de Lot: 1-25506-8

28.0	AAC1638	N° D3140-101, Doubler
------	---------	-----------------------

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)  
N° D3140-101, Doubler N° de Lot: 1-25506-1

29.0	<del>AAC1640</del> AAC1639	N° D3140-104, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
103 N° D3140-104, Doubler N° de Lot: 1-25602-10

30.0	<del>AAC1642</del> AAC1641	N° D3140-106, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
105 N° D3140-106, Doubler N° de Lot: 1-25602-11

31.0	AAC1643	N° D3140-241, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
N° D3140-241, Doubler N° de Lot: 1-25506-2

Date: Mardi, 2009-09-22 11:40:29

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22074

Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.: Machine ou Opération: Description :

32.0 AAC1645 N° D3140-303, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)

N° D3140-303, Doubler N° de Lot: 1-25506-3

33.0 NETTOYAGE Nettoyage des pièces



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le nettoyage des doublers selon IG 0063

Quantité: 1 Date: 28/10/09 Sceau:



34.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mise en place des doublers et des pièces de mousse structurales selon IF135-0002

Quantité: 1 Date: 3 Mars 09 Sceau: C.G.



35.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

36.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

37.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

38.0 AC0882 Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

39.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

40.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012

Quantité: 1 Date: 3 Mars 09 Sceau:



41.0 CUISSON Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièces selon IF135-0002, IG 0012, et PTN #20 N° de Cuisson: 6/37

ate: Mardi, 2009-09-22 11:40:29  
utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22074

Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.: Machine ou Opération: Description :

Quantité: 1 Date: 3/11/09 Sceau:

42.0 DÉMOULAGE Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson de sur la pièce et enlever les résidu de ruban adhésif en teflon et les barre d'aluminium, garder seulement la barre qui sépare les deux pièces.

Quantité: 1 Date: 4/11/09 Sceau:

43.0 DECOUPE Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Usinage des mousse structurales selon IF135-0002 et installer les doublers

Quantité: 1 Date: 6/11/09 Sceau: R.C.

44.0 INSPECTION Inspection générale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étapes.

Quantité: 1 Date: 6-11-09 Sceau:

45.0 AMB0211 Epoxy prepreg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)

Epoxy prepreg E-761 style 7781 N° de Lot: 1-25408-1

46.0 DRAPAGE Drapage



Commentair Setup: 0.00Hrs/ Run: 720.0000Hrs Total Run : 720.0000Hrs

Drapage de la coquille intérieur selon IF135-0002

Quantité: 1 Date: 6-11-09 Sceau:

47.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

Date: Mardi, 2009-09-22 11:40:29

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22074

Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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48.0	AC0884	Wrightlon 5200 Bleu P3
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Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

49.0	AC0885	Feutre de drainage N° Airweave N 10
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Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

50.0	AC0882	Sac à vide N° Stretchlon 700
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Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

51.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
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Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

52.0	BAGGING	Faire le bagging sur la pièce
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Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012.

Quantité: 1 Date: 10-11-09 Sceau:



53.0	CUISSON	Cuisson de pièce
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Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièces selon IF135-0002, IG 0012, et PTN #20 N° de Cuisson: 6143

Quantité: 1 Date: 11-11-09 Sceau:



54.0	DÉMOULAGE	Démoulage de la pièce
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer

Retirer la pièce du moule

Quantité: 1 Date: 13/11/09 Sceau:



55.0	INSPECTION	Inspection générale
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel"

Quantité: 1 Date: 17 nov-09 Sceau:





Date: Mardi, 2009-09-22 11:40:29  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 22074

Nom Dessin: DOOR KIT  
Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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56.0	TRIMAGE	Trimage / Rivetage
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Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le trimage de finition de la pièce selon IF135-0003

Quantité: 1 Date: 17/09/09 Sceau: M.A.



57.0	AAC1021	Dupont Primer N° 7704S
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Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)

Dupont Primer N° 7704S N° de Lot: 2-25136-3

58.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
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Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-24359-3

59.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1 Date: 17/11/09 Sceau: 10 N° Fiche mélange: N/A



60.0	SABLAGE	Sablage
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Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Faire le sablage du primer selon IF135-0003

Quantité: 1 Date: 18/09/09 Sceau: 7



61.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1 Date: 18/11/09 Sceau: 10 N° Fiche mélange: N/A



62.0	IDENTIFICATION	Identification à encre indélébile
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanisme de porte selon IG 0055.

Date: Mardi, 2009-09-22 11:40:29  
Utilisateur: marc dubé

## Feuille de Procédé

Cient: DART US DART AEROSPACE LTD  
Numéro Job: 22074

Nom Dessin: DOOR KIT  
Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.: Machine ou Opération: Description :


N° de pièce Grosse porte: D3140-06

N° de pièce Petite porte: D3140-08

N° de Job ( sur les 2 pièces): 22074

Date de fabrication (sur les 2 pièces): 19 nov 09

Sceau d'inspection.

Quantité: 1 Date: 19 nov 09 Sceau: 

63.0


INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.

Quantité: 1 Date: 19-11-09 Sceau: 

64.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Emballer et entreposer selon IG 0057

Quantité: 1 Date: 19-11-09 Sceau: 